

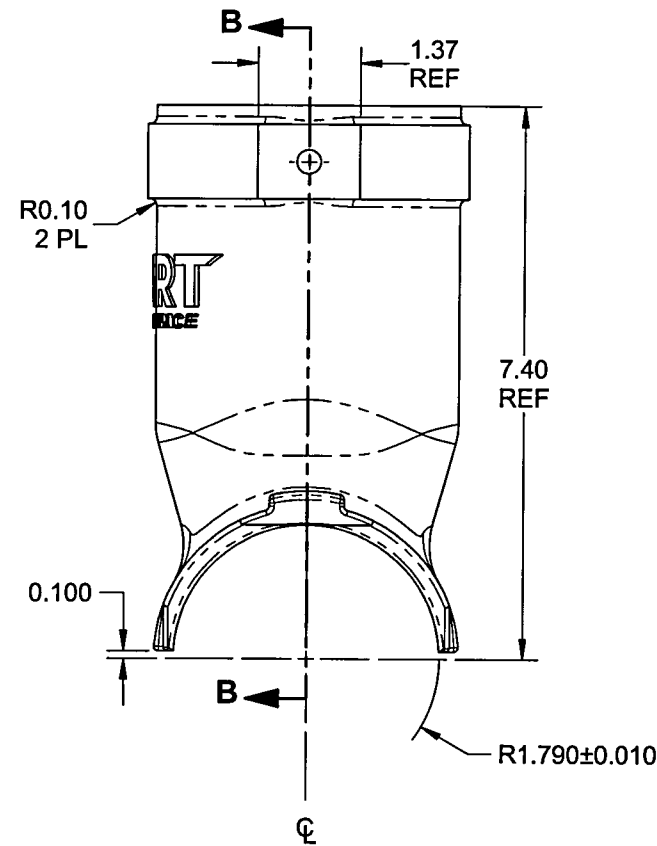
D5415-1 MID HEIGHT SADDLE

D5415-3 STANDARD HEIGHT SADDLE

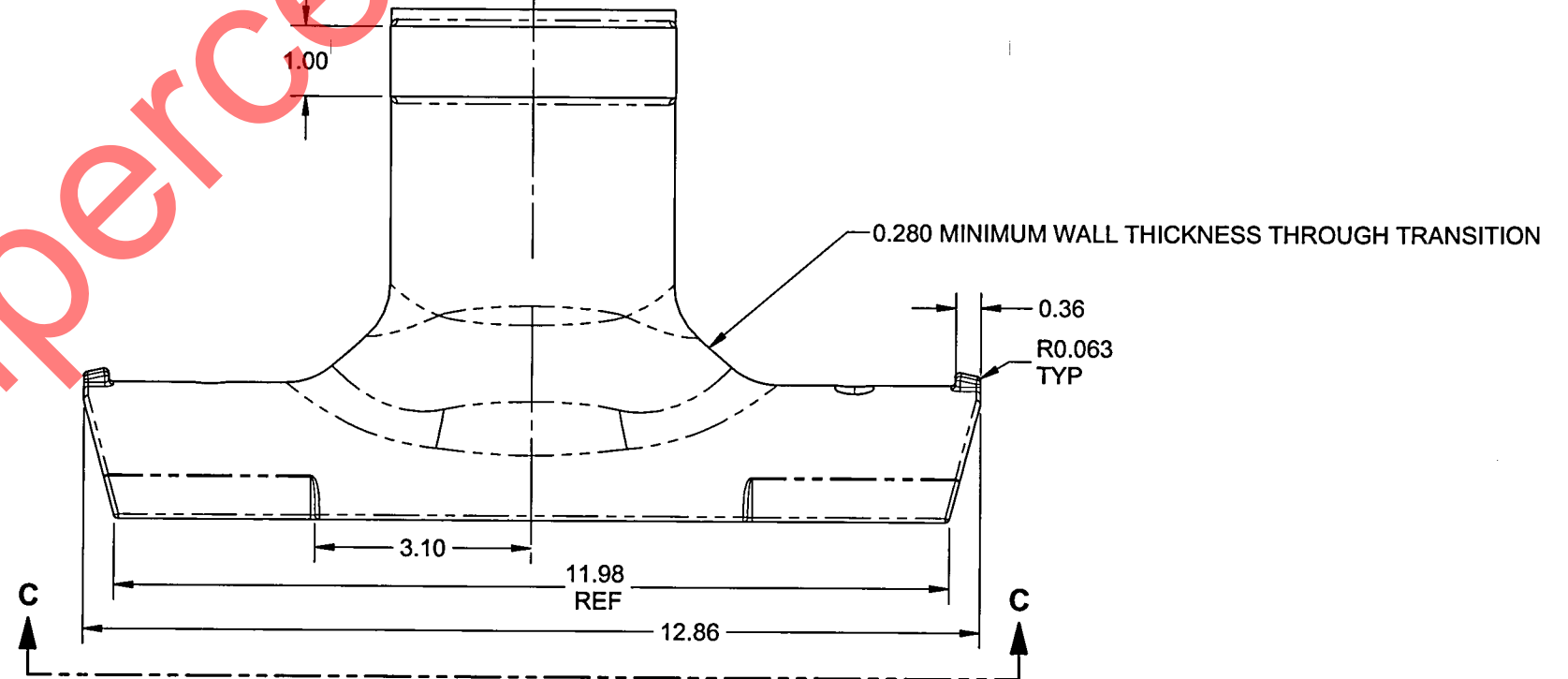
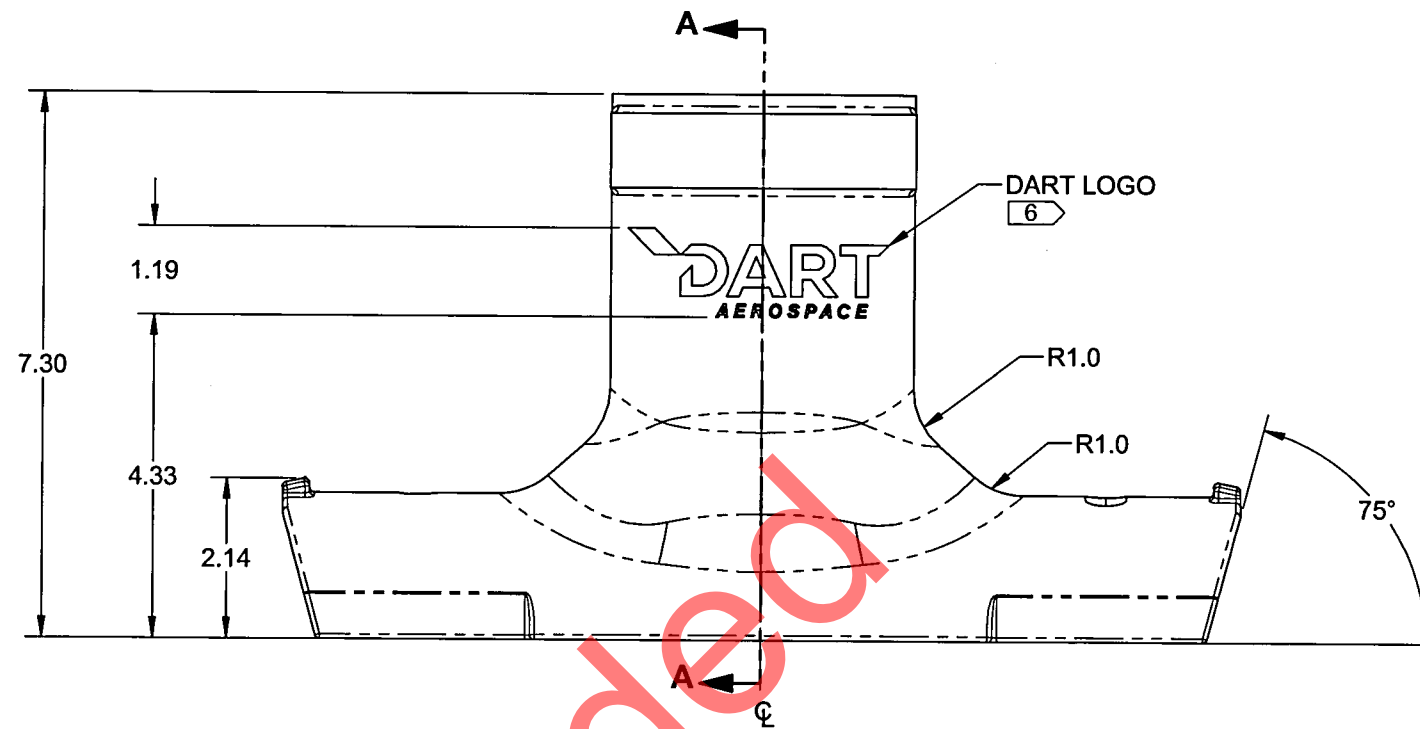
- NOTES:**
- 1) MATERIAL: MAKE FROM D5415-1C/-3C
 - 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT OUTSIDE PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PART NUMBER AND BATCH NUMBER PER QSI 044 METHOD 6.1. LOCATE APPROX AS SHOWN
 - 7) WEIGHT: D5415-1 is 3.86 LBS, D5415-3 is 3.55 LBS

RELEASED
2017-09-22
ECN17-66H

REV.	DESCRIPTION	BY	DATE
B	ADDED -3 STANDARD HEIGHT SADDLE, REVISED NOTES, REMOVED CAST P/N FROM -1 SADDLE, Ø0.323 HOLE WAS Ø0.325, SECTION B-B AND D-D ±0.005 WAS ±0.010	ML	17.09.05
A	NEW ISSUE	ML	16.05.17
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5415	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	CP	SADDLE	NTS
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D5415-1C MID HEIGHT SADDLE B

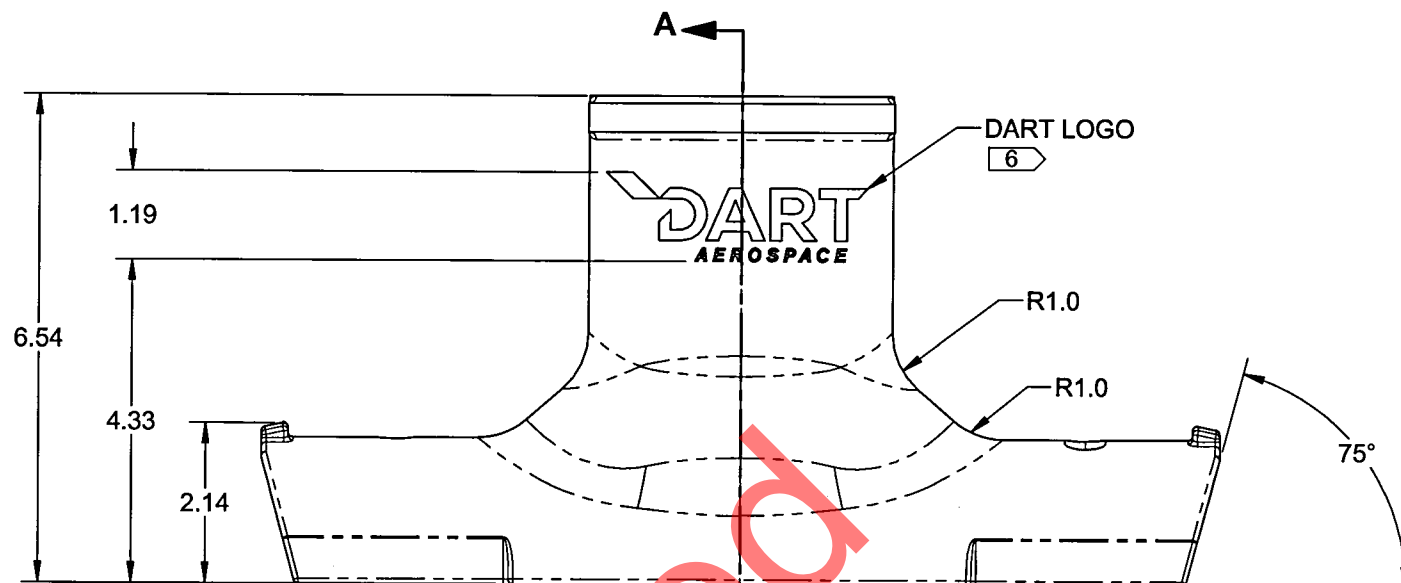
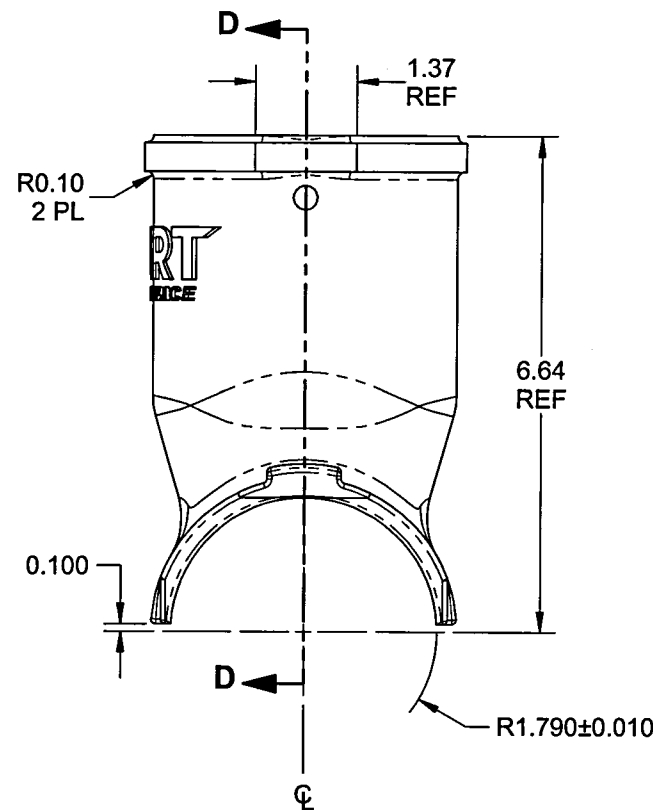


- NOTES:
- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N AND LOGO CAST INTO PART AS SHOWN
 - 7) WEIGHT: N/A
 - 8) COSMETIC WELD REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT
 - 9) INSPECTION: EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
 - 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5415-1-REV B.STP
 - 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS
NOT SPECIFIED ON THIS DRAWING.

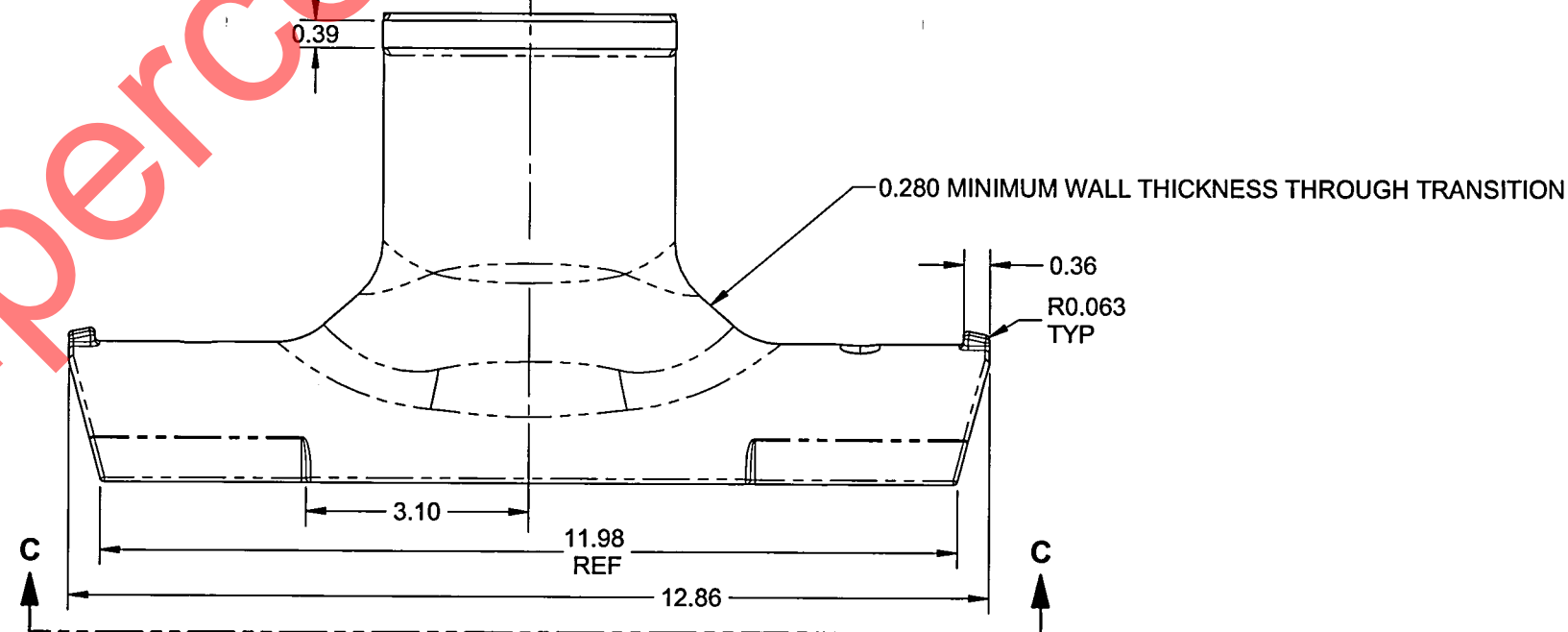
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MFG. APPR.	DD	D5415	SHEET 2 OF 4
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D5415-3C STANDARD HEIGHT SADDLE



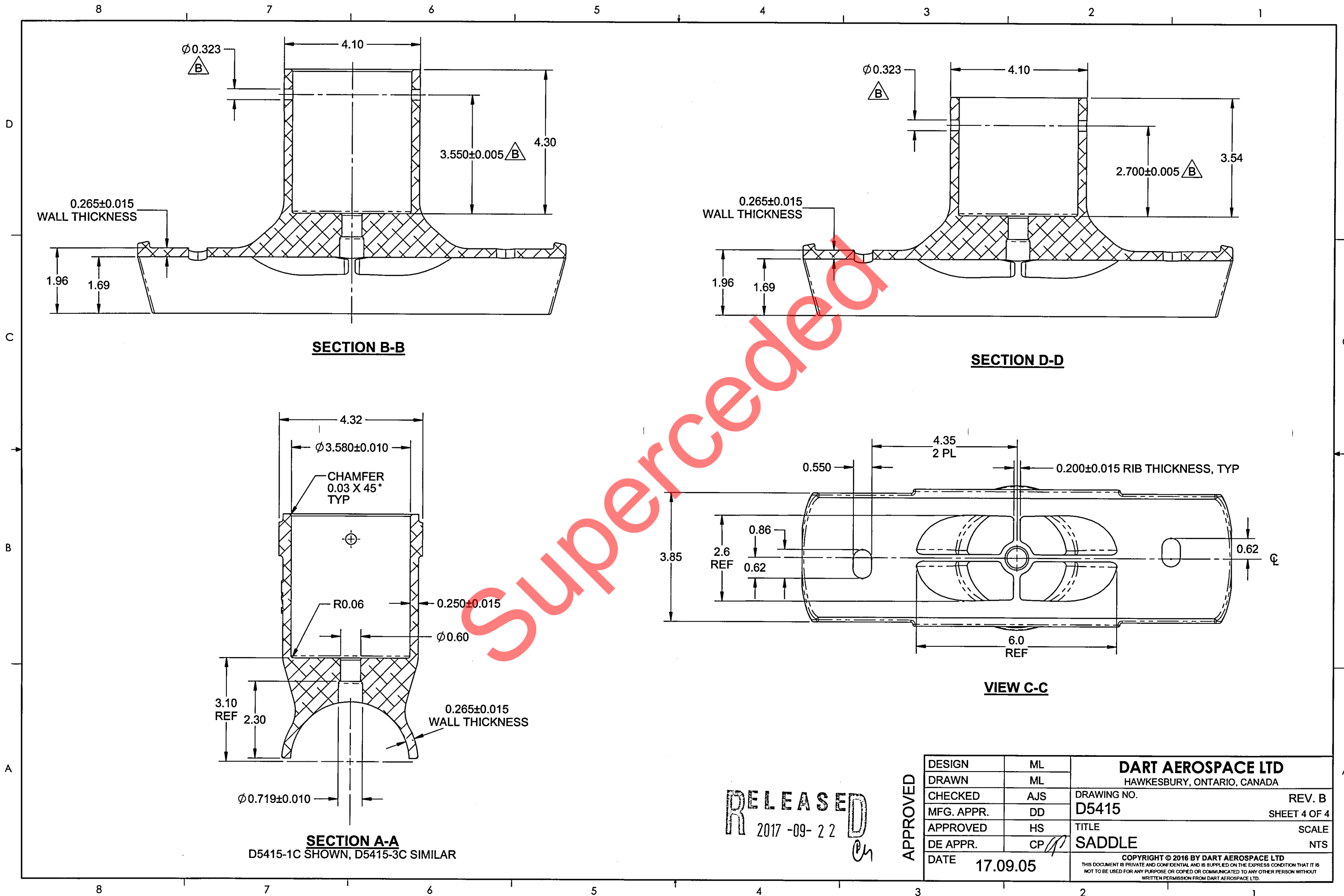
NOTES:

- 1) MATERIAL: CAST FROM F357.0 PER AMS 4289 AND HEAT TREAT TO T6 CONDITION
PROPERTIES TO BE VERIFIED BY SUB-SIZED SEPARATELY CAST TEST BARS
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N AND LOGO CAST INTO PART AS SHOWN
- 7) WEIGHT: N/A
- 8) COSMETIC WELD REPAIR PER AMS 2694 PRIOR TO INSPECTION AND HEAT TREAT
- 9) INSPECTION: EACH PART MUST PASS X-RAY CL. 1 GR. B PER AMS 2175
EACH PART MUST PASS FPI CL. 1 GR. B PER AMS 2175
- 10) ALL NON DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.030 PER
CAD FILE D5415-3-REV B.STP
- 11) ANY ADDITIONAL MATERIAL REQUIRED FOR POST-CASTING MACHINING IS
NOT SPECIFIED ON THIS DRAWING.

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